

Work Order ID 55539

January 20, 2010 7:33:27 AM



Page 1

Item ID: D3299-7

Revision ID:

Item Name: Fitting

Start Date: 1/20/10 Start Qty: 6.00

Required Date: 1/29/10 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: *U*

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3299

C

100

0.00



Doosan

Hardinge CNC LATHE SMALL

Memo

0.00

Doosan Lathe

Cut blank: 2.300" long
Turn as per Folio FA901 and Dwg D3299
FOLIO REV: *N/A*
DWG REV: *2*

SL

10/01/24

6

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL

10/01/24

6

Work Order ID 55539

January 20, 2010 7:33:27 AM

Page 2

Item ID: D3299-7

Accept

Revision ID:

Item Name: Fitting

Start Date: 1/20/10

Start Qty: 6.00

Required Date: 1/29/10

Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio FA451 and Dwg D3299: CHAMFER PART USING
CHAMFER MACHINE AS PER DWG D3299 Deburr

0.00

0.00

L.P. 10/03/11

6

130



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

L.P. 10/03/11

140



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

Ind 10.03.11

6

Ø

Work Order ID 55539

January 20, 2010 7:33:28 AM



Page 3

Item ID: D3299-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

Start Date: 1/20/10 Start Qty: 6.00



Cust Item ID:

Required Date: 1/29/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Outsource4

Outsource process-Anodize per QSI017 4.1.10.1

0.00

Memo

0.00

Outsource process - Anodize

Issue P/O: 11492 Anodize as per Dwg D3299: Possible
Supplier: TNM Paint! Material release note is required

CZ 10/3/11 6

160



Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Packaging

Ensure Material Release Note is attached

P 10/3/18 6

170



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

8 6/6/17

(40)

Work Order ID 55539

January 20, 2010 7:33:28 AM



Page 4

Item ID: D3299-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

Start Date: 1/20/10 Start Qty: 6.00



Cust Item ID:

Required Date: 1/29/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start

Picklist Print

January 20, 2010 7:33:27 AM

Page 1 / 1

Work Order ID: 55539



Parent Item: D3299-7

Parent Item Name: Fitting

Start Date: 1/20/10

Required Date: 1/29/10

Comments: IPP REV:A NEW ISSUE 10-01-19 JLM VERIFIED BY:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	54.8800	1.2107			



6061-T6 Bar 1.25 x 1.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

54.88

106259

14

109058

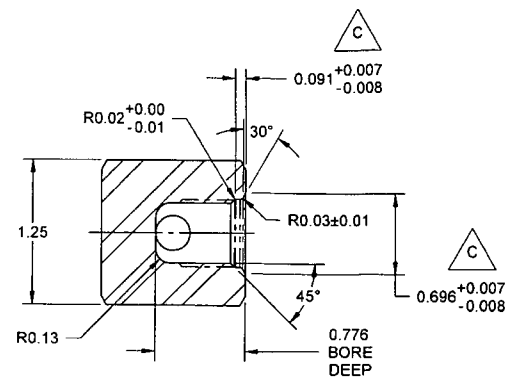
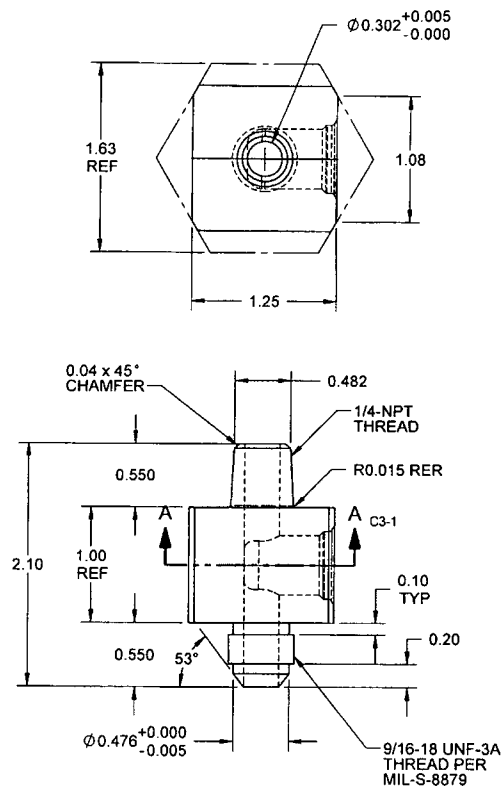
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110001

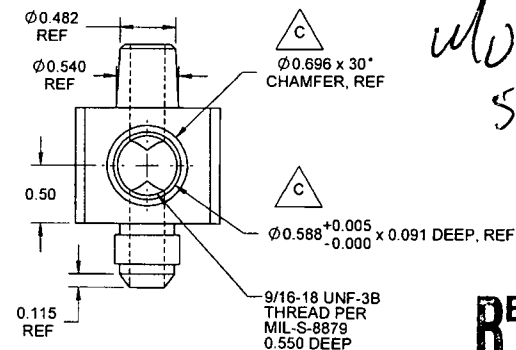
19.45

1.211

SL 10/01/24



SECTION A-A C5-1



RELEASED
2010-01-14

NOTES:

MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM 1.63" HEX BAR
PER QQ-A-200/8 OR QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6H1.625

2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TMM PAINT

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

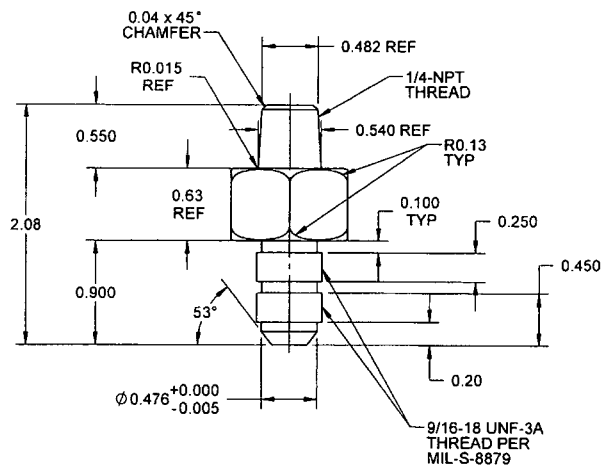
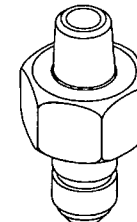
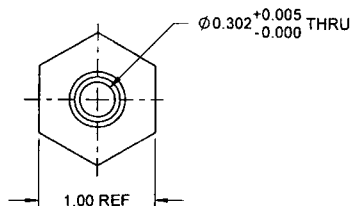
5) BREAK SHARP EDGES: EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3299-1" & B/N USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 0.43 lbs

D3299-1 FITTING

C	DRAWING UPDATED TO CURRENT STANDARDS. ADD -7 (ZN A4-4); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN D2-1, C2-1, B2-1, D5-4, C4-4, B4-4, C1-4) PER CAR 09-004	RF	09.12.30
B	1.09 WAS 0.837; 0.302 WAS 0.297	RF	05.04.28
A	NEW ISSUE	RF	04.07.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3299	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FITTING	NTS
DATE	09.12.30	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



46
55539

RELEASED
2010-01-14

D3299-3 FITTING

NOTES:

MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM 1.00" HEX BAR
PER QQ-A-200/8 OR QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6H1.000

2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

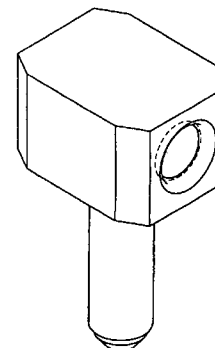
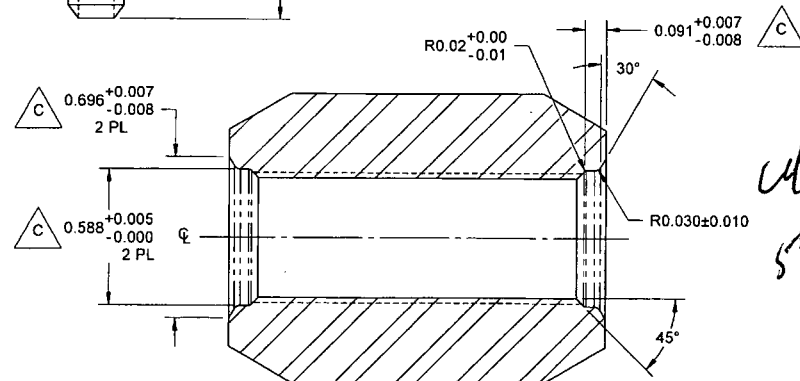
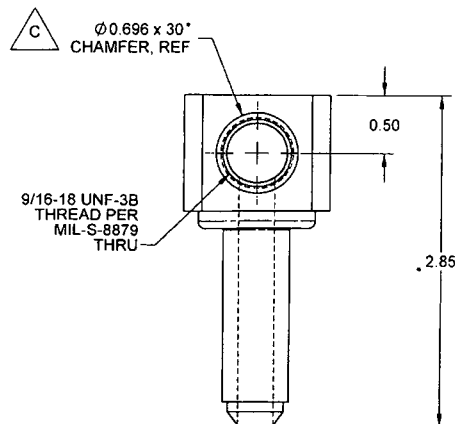
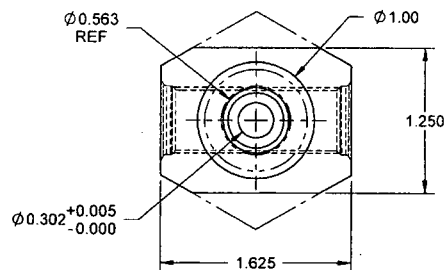
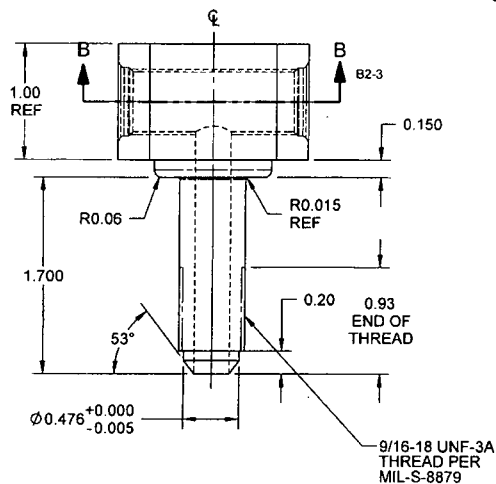
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3299-3" & B/N USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 0.20 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3299	SHEET 2 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FITTING	NTS
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u/b
55539

SECTION B-B D6-3
SCALE 2X

RELEASED
R 2010-01-18

D3299-5 FITTING

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM 1.63" HEX BAR
PER QQ-A-200/8 OR QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6H1.625
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3299-5" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.57 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3299	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FITTING	NTS
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DART AEROSPACE LTD		Work Order: 55539
Description: Fitting		Part Number: D3294-7
Inspection Dwg: D3294	Rev: C	Page 1 of 1

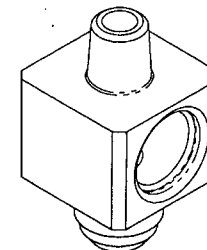
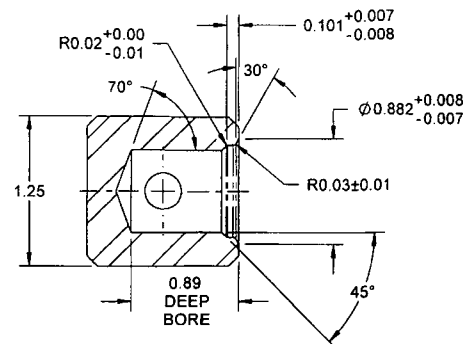
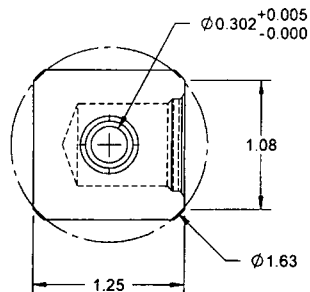
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

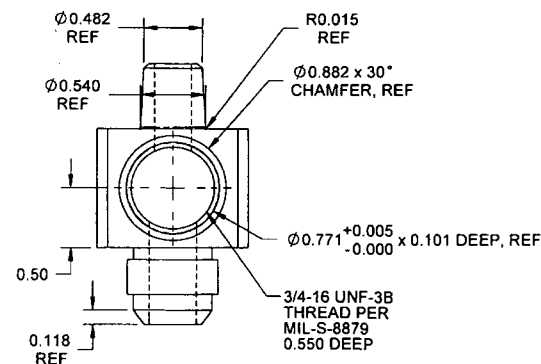
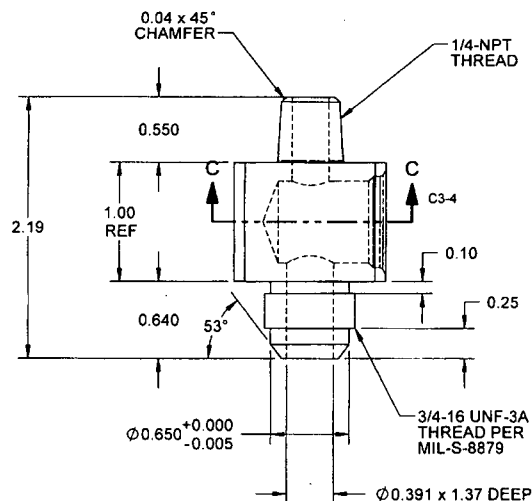
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	$\pm .030$	1.249	✓			
1.63	$\pm .030$	1.645	✓			
Ø.302	$\pm .005$ -0	.304	✓			
1.08	$\pm .030$	1.086	✓			
.04x45°	$\pm .030$ $\pm .5^\circ$.04x45°	✓			
1/4-NPT		1/4-NPT	✓			
.550	$\pm .010$.550	✓			
1.00	$\pm .030$.999	✓			
2.19	$\pm .030$	2.190	✓			
.640	$\pm .010$.641	✓			
53°	$\pm .5^\circ$	53°	✓			
.650	$\pm .005$ +0	.647	✓			
Ø.391	$\pm .006$ -0.001	.395	✓			
3/4-16 UNF		3/4-16 UNF	✓			
.25	$\pm .030$.249	✓			
.10	$\pm .030$.100	✓			
.482	$\pm .010$.482	✓			
.540	$\pm .010$.539	✓			
.118	$\pm .010$.115	✓			
Ø.771x.101	$\pm .005$ / $\pm .010$ -0.005	.773 / .098	✓			
Ø.882	$\pm .010$.875	✓			

Measured by: SL	Audited by: [Signature]	Prototype Approval: N/A
Date: 10/01/24	Date: 10.03.11	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



SECTION C-C C5-4



W/D 55539



D3299-7 FITTING

RELEASED
2010-01-16
M/D

NOTES:

MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IC OR IL OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3299-7" & B/N USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 0.40 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3299	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FITTING	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO11492**

Purchase Order Date 3/11/10

PO Print Date 3/11/10

Page Number 1 of 2

Order From :

VC-AND002

ANODIZING & PAINT T.N.M. INC.
21 AVIATION ROAD
POINTE CLAIRE, QC H9R 4Z2
CA

FAKED
6/10/31/10

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	514 429 7777	Requisition Nbr	
Vendor Fax	514 429 5108	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

*Please
* Rush need you the *
16 of march*

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	55540	D3299-1 FITTING	3/18/10 Yes	2.00	Purolator ground	\$7.5000	\$15.00
Special Inst:			BLUE ANODIZE AS PER: MIL-A-8625F TYPE 1 / 1B / 1C / 11/ 11B				
2	55530	D3299-3 FITTING	3/18/10 Yes	6.00	Purolator ground	\$7.5000	\$45.00
Special Inst:			SAME AS ABOVE				
3	55531	D3299-5 FITTING	3/18/10 Yes	6.00	Purolator ground	\$7.5000	\$45.00
Special Inst:			SAME AS ABOVE				
4	55539	D3299-7	3/18/10 Yes	6.00	Purolator ground	\$7.5000	\$45.00
Special Inst:			SAME AS ABOVE				

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 3/11/10



Packing Slip

21 chemin de l'Aviation, Pointe-Claire
QC H9R 4Z2
Canada
Phone:514-429-7777 Fax:514-429-5108
EMail:info@tnminc.ca

DATE

PACKING SLIP #

3/16/2010

- 84045



BILL TO:

SHIP TO:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

No. De Commande/PO#	CUST	TERMS	REP	SHIP	VIA	F.O.B	JOB NUMBER
11492	0094	NET 30		3/16/2010	Purolator		123504-001

PO Line#: 01

QTY DUE	QTY SHIPPED	QTY B/O	DESCRIPTION
20	20	0	P/N:VARIOUS TNM-REV:P1
2	2		P/N:D3299-1 FITTING
6	6		P/N:D3299-3 FITTING
6	6		P/N: D3299-5 FITTING
6	6		P/N: D3299-7 FITTING

Sign Here: _____

En cas de perte ou de dommages dû à la valeur intrinsèque de certaines pièces, la responsabilité se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.
Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

Packing Slip PACK01 REV: PACK01



Anodisation & Peinture TNM Inc
Anodizing & Paint TNM Inc

21 chemin de l'Aviation, Pointe-Claire QC H9R 4Z2
Telephone 514-429-7777 Fax 514-429-5108
AS9100 Rev B Certified QMS, Nadcap, Chemical & NDT

3/16/2010
FACTURE 84045
INVOICE
Rev.



CLIENT / CUSTOMER:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

PURCHASE ORDER/ 11492
NO. DE COMMANDE:

CONDITIONS/TERMS:
NET 30 JOURS/NET 30 DAYS

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PRIX UNITAIRE UNIT PRICE	EXTENSION
53361824	20	20	P/N:VARIOUS REV:P1 FITTING	\$7.50	\$150.00
53361825		1	Shipping Charges	\$0.00	\$0.00

SUB TOTAL: \$150.00
TPS/GST(5.00%): \$7.50
SUBTOTAL: \$157.50

TOTAL AMOUNT DUE: \$157.50

No de TPS / GST # : 891559734 RT CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE
No de TVQ / QST # : 1019307154 TQ000 CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS

En cas de perte ou de dommages dû à la valeur intrinsèque de certaines pièces, la responsabilité se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.
Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

**Anodisation & Peinture TNM Inc**

21 chemin de l'Aviation, Pointe-Claire QC H9R 4Z2
Telephone 514-429-7777 Fax 514-429-5108
AS9100 Rev B Certified QMS, Nadcap, Chemical & NDT

C of C: 84045



3/16/2010

CLIENT / CUSTOMER:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE**

**PURCHASE ORDER /
NO. DE COMMANDE:**

11492

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION PROTECTIVE FINISH CODES	PART-PROCESS & TREATMENT
1	20	20	P/N:VARIOUS TNM-REV:P1 FITTING 55540 D3299-1 QTY 2 55530 D3299-3 QTY 6 55531 D3299-5 QTY 6 55539 D3299-7 QTY 6	BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

8/05/19

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and Inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

Signature/Signed: _____

Directeur de la Qualité / Q.A. Manager

